

Work Order ID 53222

October 27, 2009 12:39:58 PM



Page 1

Item ID: D3859-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearplate

Start Date: 27/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: *PS*

Date: *09-10-27* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
<i>D3859</i>	<i>A</i>								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 ☒ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

HB 9-10-30

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-10-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8 or 10/30

(KS)

f

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3859 <input type="checkbox"/> A/R 316L stainless steel rod Batch: <u>M109160</u> <input type="checkbox"/> 2-Weld hard facing as per Dwg D3859 <input type="checkbox"/> A/R 2059B Hard Coat rod Batch: <u>112 963</u> <input type="checkbox"/> *****use DT9462 for welding*****								
140 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
150 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

EL 9-11-4

PD 09.11.05 8

=> Sorullos

7

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Item ID: D3859-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearplate

Start Date: 27/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06

mf
09-11-05

Picklist Print

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Page 1

Work Order ID: 53222

Parent Item: D3859-041RevA

Parent Item Name: Wearplate



Comments:

Start Date: 27/10/2009

Required Date: 12/11/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	212.6506	4.2500	7.000		
												
B 9-10-30												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

212.6505737

106860

16.018

111924

25.1689737

112442

43.1663

112567

0.2973

112885

128

D3009-3RevB

Manufactured No

130 Each

609.0000 30.0000



Cup



B 9-11-4

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

609

42376

158

42377

451

48

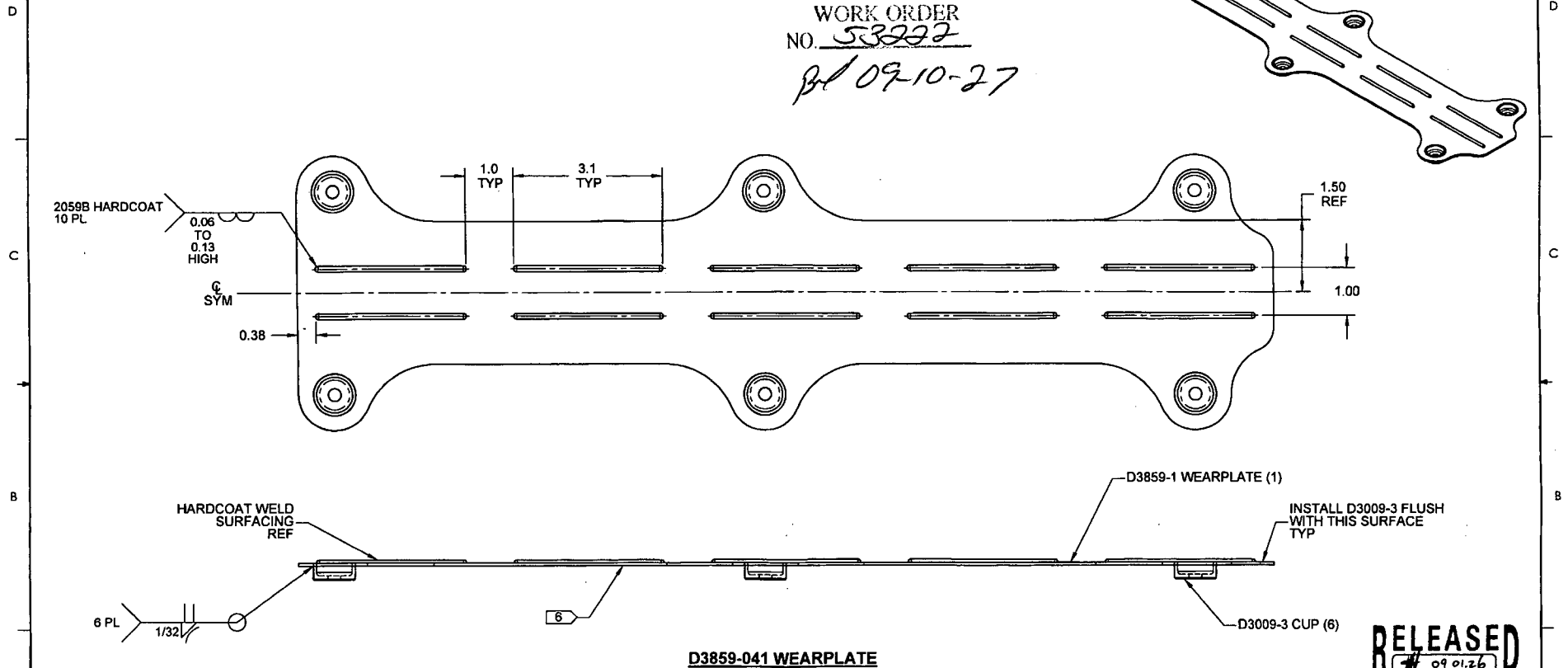
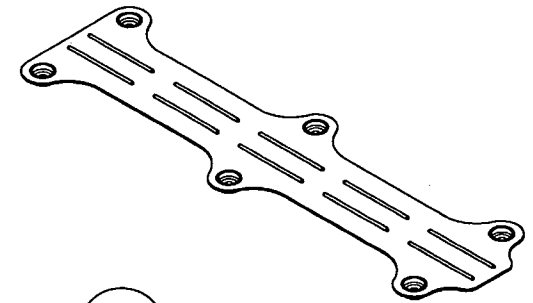
SHOP COPY

RETURN TO

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

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WITHOUT NOTICE
WORK ORDER
NO. 53222

BL 09-10-27



D3859-041 WEARPLATE

RELEASED
09 01.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.01.26			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3859** REV. A
SHEET 1 OF 2

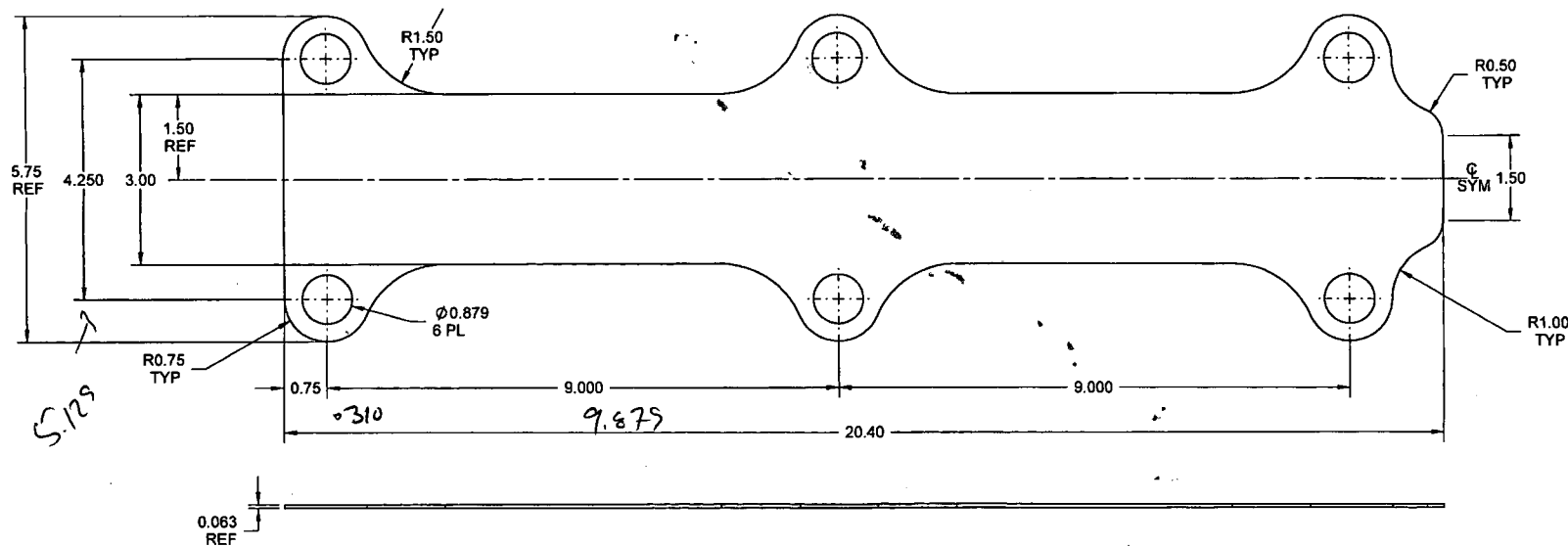
TITLE **WEARPLATE** SCALE NTS

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WORK ORDER
NO. 53222



D3859-1 WEARPLATE

RELEASED
09.01.26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3859	REV. A
MFG. APPR.		TITLE WEARPLATE	SHEET 2 OF 2
APPROVED		SCALE	NTS
DE APPR.			
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